

Green

Dart Aerospace Ltd.

Date: Tuesday, 07/04/2009 3:22:01 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLADE POSITIONER WELDMENT
Job Number	: 47056		
Estimate Number	: 13443		
P.O. Number	:	Part Number	: PB674300129
This Issue	: 07/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: B6743001 P.40
First Issue	: 07/04/2009	Project Number	: N/A
Previous Run	: 45032	Drawing Revision	: B1
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 20/04/2009
Checked & Approved By	: <u>MF 09-04-08.</u>	Qty:	1
Comment	: Est Rev:A 08-06-27 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB6743001313	Plate
✓		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Plate batch: <u>B44968</u>		
2.0	PB6743001319	Gusset
✓		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Gusset batch: <u>B41504-1 B44967</u>		
3.0	PB6743001337	Upper Pad Assembly
✓		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Upper Pad Assembly batch: <u>B44966</u>		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 ****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG. MOVEMENT OF -285 EACH SIDE OF VERTICAL, PRIOR TO WELDING**** 1- ASSEMBLE AND WELD AS PER DWG		
5.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/04/15 (X)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

09-04-16 (X)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 2:20pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:50pm

09-04-16 (X)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/04/16 (X)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST444

09/04/17 (X)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 (X)

Job Completion



ME 09-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

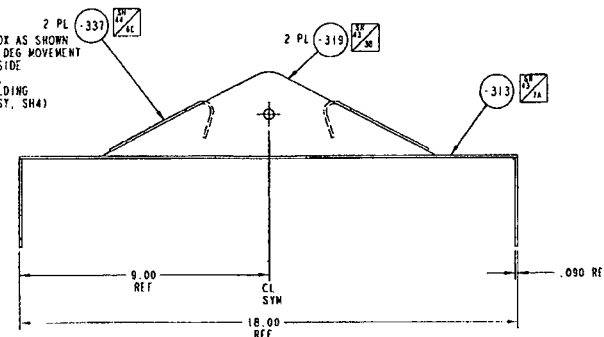
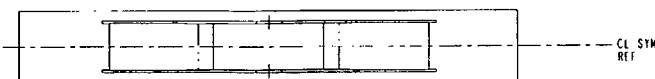
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

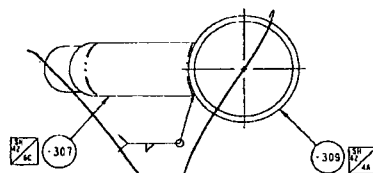
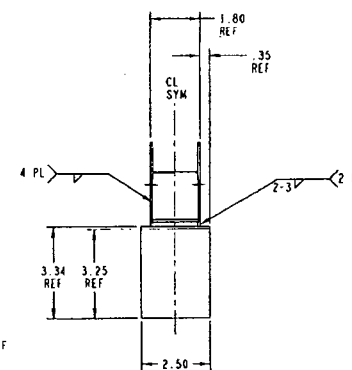
NOTE: Date & initial all entries

RELEASED
46 01.20

2 PL -337
LOCATE APPROX AS SHOWN
ASSURING 45 DEG MOVEMENT
OF -2B5 EA SIDE
OF VERTICAL
PRIOR TO WELDING
(SEE -27 ASSY, SH4)



① -29 BLADE POSITIONER WELDMENT
SCALE 0.500

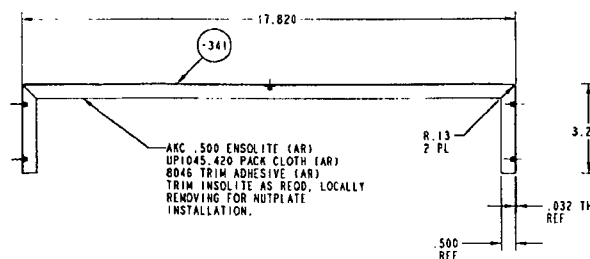
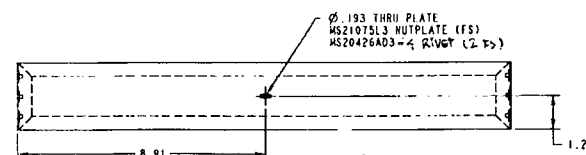


-25 TUBE GUIDE WELDMENT

SCALE 1.000

SUPERCEDED BY

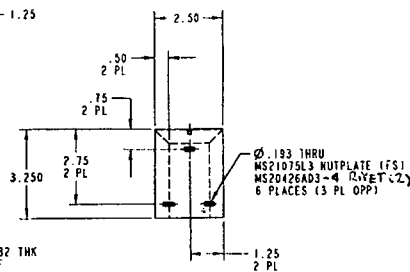
DB440-1 & DB440-3



① -35 LOWER PAD ASSY

SCALE 0.500
MATERIAL FOR -341: .032 THK 2024-T3, 00-A-250/4

47056



PREMIER AVIATION, INC.
3000 Aviation Parkway, Grand Prairie, Texas 75052

SIZE CODE 100" NO. DWG NO. 01050V8 B67-43001 B1
SCALE: 1:1 SHEET 40 OF 45

ORIGINAL